

## Clifa® press-in nut/stud ...

Clifa press-in nuts and Clifa studs are threaded inserts made of steel with a specially formed shank or head.

Clifa press-in nuts and Clifa studs can also be supplied in rust-proof material, and the nuts additionally in light alloy.

Clifa threaded inserts are pressed into moulded components with prepunched receiving holes. During this process, the material flows out of the area of the hole wall into the gear ring / the annular grooves of the Clifa threaded inserts. A permanent connection is formed.

Several Clifa inserts can be installed in a single work process. The fastening screw is always screwed in from the opposite side.

### Fields of application

Clifa press-in nuts and Clifa studs are used to fasten all different types of appliance components, as spacers pins and bushings for plastics, e.g. circuit boards etc.

### Product features

- Clifa is torque-proof, wear-resistant and capable of withstanding high loads
- It has minimal outside dimensions for space and weight-saving designs with an attractive appearance
- The thread is wear-resistant, clean and true to gauge
- Clifa is not pressed out during the screwing process
- For sheet metal thicknesses below 1,0 mm: Thin sheet metal press-in studs.

### Specifications

Works Standard sheets Clifa  
Pages 11 to 20

High-performance installation equipment for short cycle times in largescale production on request.



# Clifa® installation ...

## Installation

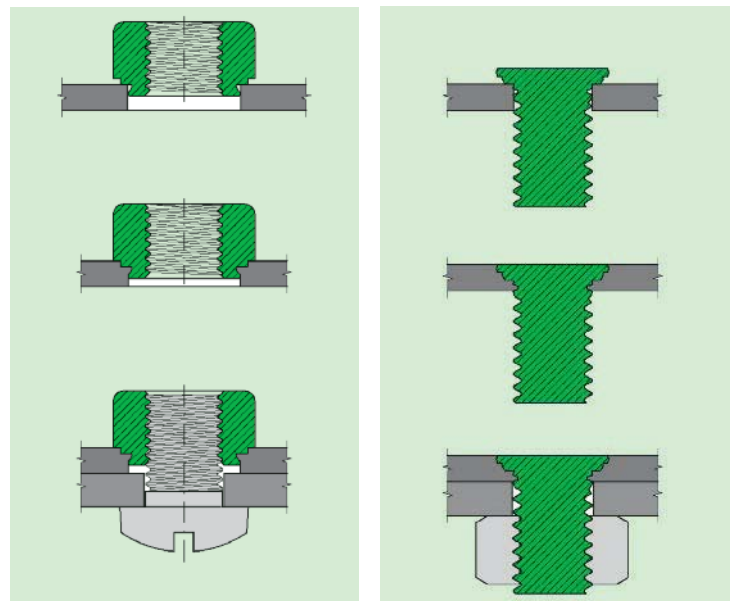
The receiving hole is punched or drilled, **but not deburred or countersunk.**

With punched holes, Clifa is pressed in from the punching burr side. The press-in process takes place on a plane parallel basis using a customary press with adjustable pressure level, until the surface of the shoulder in the Clifa press-in nut comes to rest flat against the surface of the sheet metal.

In the case of the Clifa-SP/SPD/SPG/SPS and SR stud, the head must be fully pressed in and come to rest flush with the surface of the sheet metal.

Pressure which is too high or applied only on one side as well as inclined support surfaces must be avoided wherever possible..

## Examples for mounting



Press-in nut Clifa

Press-in stud Clifa-SP


## Special request

- short length
- standoff bushings for metals
- standoff bushings for plastics
- threaded press-in stud for thin sheet metals < 1,0 mm
- threaded press-in stud for high force
- threaded press-in stud for epoxy resin moulding materials
- threaded press-in stud for lower press-in force

## We recommend

- Clifa-M (Works Standard 500 0 to 503 0)
- Clifa-AM (Works Standard 503 8 to 525 8)
- Clifa-AL (Works Standard 503 6 to 525 6)
- Clifa-SPD (Works Standard 5.. 2)
- Clifa-SA (Works Standard 515 4 to 534 4)
- Clifa-SL (Works Standard 506 7 to 518 7)
- Clifa-SR (Works Standard 5.. 1)





### Press-in nut / standoff bushings for plastics

### Clifa®-AL

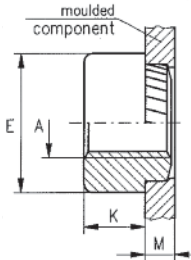
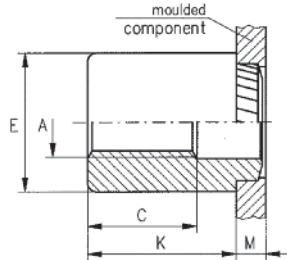
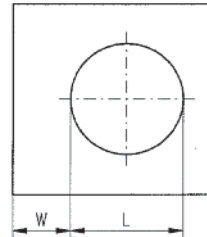
Works Standard  
503 6 to 525 6

**Application**

These Clifa press-in nuts are particularly suited for creating torque-resistant screw connections capable of withstanding high loads in thin-walled moulded parts from 1,5 mm in thickness.

- Epoxy glass fibre
- Phenolic resin
- Fibreglass (e.g. printing plates).

Also suitable for aluminium and magnesium

Dimensions in mm

Article no.	Internal thread A	External diameter E	Workpiece thickness min. M	Hole diameter: Tolerance + 0,1 L	Minimum spacing W
5.. 600 020 ...	M 2	6,0	1,5	3,7	2,2
5.. 600 025 ...	M 2,5	6,0	1,5	4,2	2,4
5.. 600 030 ...	M 3	7,0	1,5	4,2	2,4
5.. 600 040 ...	M 4	8,0	1,5	6,4	3,3
5.. 600 050 ...	M 5	9,0	1,5	6,8	4,1

**Example for finding the article number**

Diagonally serrated press-in nut Clifa AL with internal thread M3, nut height 8,0 mm, made of hardened, pre copper plated and tinned steel: Clifa-AL 508 600 030.100


**Nut height K available between 3,0 and 25 mm in 1,0 mm graduations.**  
The second and third digit of the article number is used to identify the nut height K.  
With nut heights > 9,0 mm, the usable thread length remains C 9,0 mm.

**Materials**

Steel, hardened, pre copper plated and tinned      Article no. (**fourth** group of digits) ... 100  
Stainless steel 1.4305      Article no. (**fourth** group of digits) ... 500  
Other finishes on request.

**Tolerances**  
ISO 2768-m

**Thread**  
Internal thread A: as per ISO 6H



### Press-in stud for plastics

### Clifa®-SL

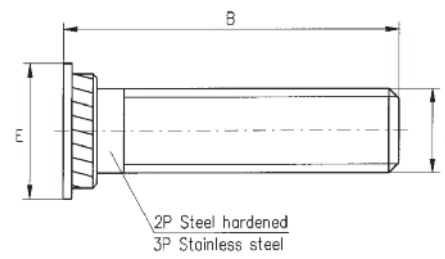
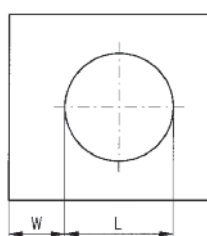
Works Standard  
506 7 to 518 7

**Application**

These Clifa press-in studs with diagonal serrations are particularly suited for creating torque-resistant screw connections capable of withstanding high loads in thin-walled moulded parts from 1,5 mm in thickness.

- Epoxy glass fibre
- Phenolic resin
- Fibreglass (e.g. printing plates).

Also suitable for aluminium and magnesium.

Dimensions in mm

Article no.	Thread A	Length B	Head diameter E	Workpiece thickness min. M	Hole dia. Tolerance +0,1 L	Minimum wall thickness W
5.. 700 030 ...	M 3	6,0 to 16,0	6,0	1,5	4,2	2,4
5.. 700 040 ...	M 4	6,0 to 16,0	7,0	1,5	6,4	3,3
5.. 700 050 ...	M 5	10,0 to 18,0	8,0	1,5	6,4	3,3

**Example for finding the article number**

Diagonally serrated press-in stud Clifa SL, M3, length B = 10,0 mm, made of hardened, pre copper plated and tinned steel: Clifa-SL 510 700 030.100

**Stud length from 6,0 mm to 18,0 mm available in graduations of 1,0 mm.**  
The second and third digit of the article number is used to identify the length..

**Materials**

Steel, hardened, pre copper plated and tinned      Article no. (**fourth** group of digits) ... 100  
Stainless steel 1.4305      Article no. (**fourth** group of digits) ... 500  
Other finishes on request.

**Tolerances**  
ISO 2768-m

**Thread**  
Stud thread A: as per ISO 6g. **Imperial thread available in customary sizes**

## Fasteners for special applications ...

Press-in stud with special part-end



Rivet bushing with double riveting contour



Press-in nut with three cross-holes



Press-in stud with segmented head



Rivet bushing with fine thread on outer diameter



Rivet bushing with special sealing contour



Bolt with T-groove for fixing/locking of screw-in elements



Riveting nut loosely riveted with TufLok® coating



Press-in nut with double knurling contour

